

Date: Wednesday, 03/09/2008 10:28:24 AM
User: Julie Lecocq

Process Sheet

SP115

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (13"X24")
Job Number : 41734	
Estimate Number : 11540	
P.O. Number :	Part Number : D206559023
This Issue : 03/09/2008 S.O. No. :	Drawing Number : D2672 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 39081	Material :
Written By :	Due Date : 30/09/2008 Qty: <i>5/20</i> Um: Each
Checked & Approved By : <i>JLD 08.9.03</i>	
Comment : Est Rev: E 04.02.17 Tolerance added to Step 3 KJ/JLM Est Rev: F 07-01-02 Was K10006 JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.9.24



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-023 CHG006

S 08/10/21

2.0 MUHMWB10 UHMW 1" Black



Comment: Qty.: 4.8300 sf(s)/Unit Total : 28.9800 sf(s)
blank: 13.250" x 24.25" x 1.00" thick (+0.030/-0.000) per DSK086-2
Material: Black UHMW 1"
(MUHMWB10)
Batch: *M109497*

Rq 08/10/15 (10) M.A 08/10/07

P10

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2672 Identify as D2672

3-Deburr

M.A 08/10/16 / 20 08/10/15

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 08/10/16/20 08/10/15 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-559-023 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 08/10/22

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41734</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/10/22</u>	<u>2.0</u>	<u>2 blanks scrap because Emill 1.1ts part. - Added new clamps to fix.</u>	<u>[Signature]</u> <u>05/10/22</u>	<u>Scrap 2. no replace Qty 2</u> <u>drill 2. top new clamp locations.</u>	<u>[Signature]</u> <u>08/10/20</u>	<u>[Signature]</u> <u>08-10-20</u>	<u>[Signature]</u> <u>05/10/22</u>	<u>[Signature]</u> <u>08-10-20</u>
		<u>RC: Set-up process</u>						

NOTE: Date & initial all entries

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Job Number: 41734

Part Number: D206559023

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/10/20

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Rubber Cushion



Comment: Qty.: 2.5000 f(s)/Unit Total: 15.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

39986 x 5

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2672(ref only) Bearpaw

41422

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 36.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

B39440 x 20

B411428 x 16

Need to fix these
Qty's in comp.

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer

41431

08/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 10:28:25 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (13"X24")

Job Number: 41734

Part Number: D206559023

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4160 Each(s)/Unit Total : 2.4960 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion 38509

AS 08/10/21 (x6)

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M108868

AS 08/10/21 (x6)

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M109001

AS 08/10/21 (x6)

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M108827

AS 08/10/21 (x6)

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M108145

AS 08/10/21 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

508/10/21 (X)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-023

Location: A

8/10/21

(SX)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/21

Job Completion



MF 08-10-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

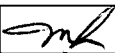
NOTE: Date & initial all entries



DART AEROSPACE LTD		Work Order: 41734
Description: Bearpaw		Part Number: D2672
Inspection Dwg: D2672	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	✓			
B	12.750	+/-0.030	12.750	✓			
C	4.250	+/-0.010	4.249	✓			
D	2.000	+/-0.030	2.000	✓			
E	9.000	+/-0.010	8.998	✓			
F	0.375	+/-0.030	0.381	✓			
G	9.000	+/-0.010	8.996	✓			
H	Ø0.260	+0.005/-0.000	Ø0.260	✓			
I	Ø0.93	+/-0.030	Ø0.933	✓			
J	0.300	+0.030/-0.000	0.308	✓			
K	0.625	+/-0.030	0.628	✓			
L	0.063 x 45°	+0.030/-0.010	0.075 x 45°	✓			
M	0.250	+/-0.010	0.253	✓			
N	5.500	+/-0.030	5.503	✓			
O	R0.250	+/-0.030	R0.250	✓			
P	0.200	+/-0.030	0.208	✓			
Q	0.25 x 45°	+/-0.030	0.254 x 45°	✓			
R	0.950	+0.030/-0.010	0.956	✓			
S	0.375	+/-0.010	0.380	✓			

Measured by: M.A	Audited by: 	Prototype Approval: N/A
Date: 08/10/16	Date: 08/10/16	Date:

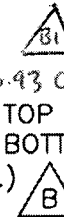
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF 	



DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
KE	KE	D2672
DATE	TITLE	REV. B
98.05.19	BEARPAW	SHEET 1 OF 2
A	97.04.08	NEW ISSUE
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50
B1	02.10.22	φ0.43 WAS φ0.75
SCALE		1:5

ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)

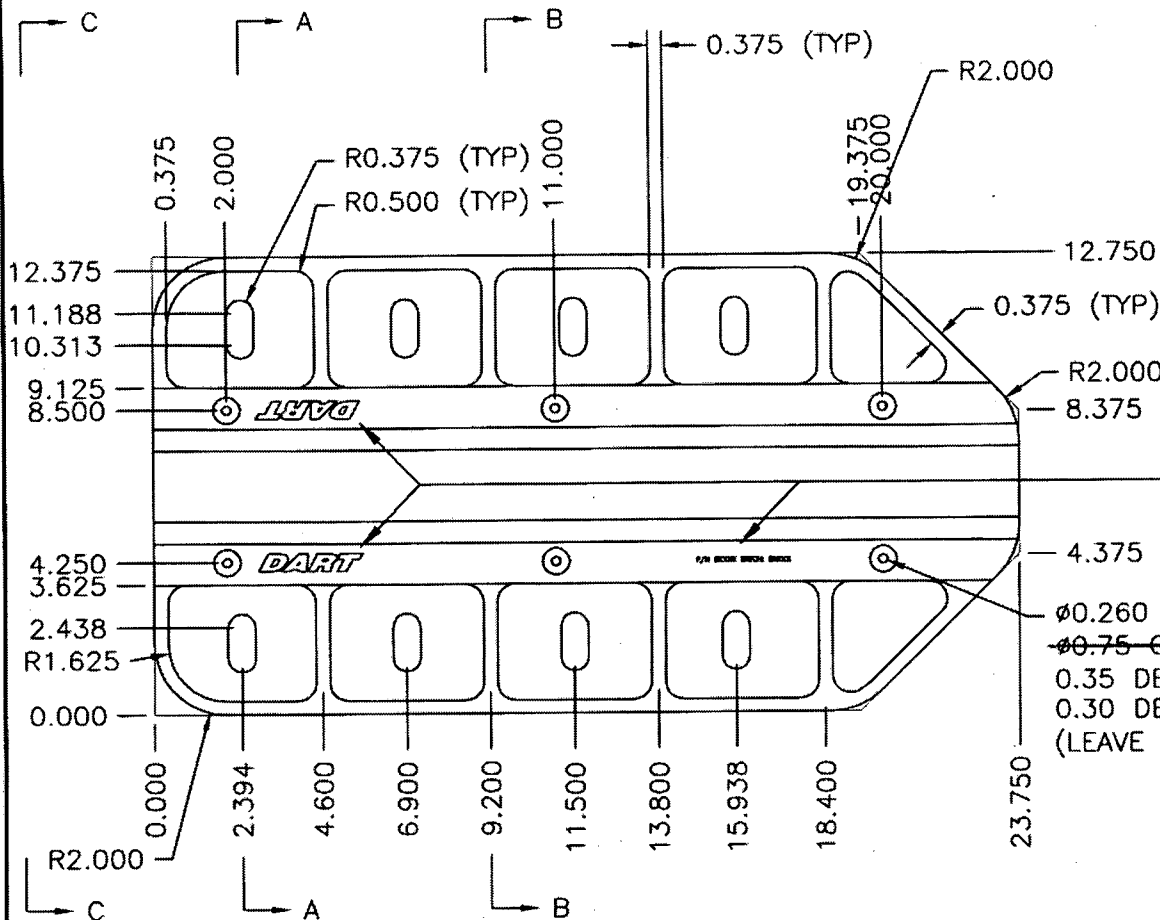
φ0.260 (TYP)
~~φ0.75 C'BORE~~ φ0.43 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)



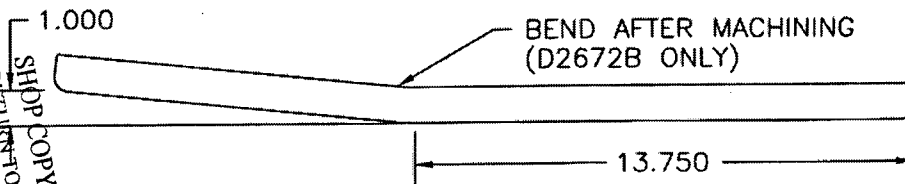
EFFECTIVE DEOS

9/14/3	
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RELEASED
98.06.17 KS



FLAT PATTERN



D2672F: FLAT BEARPAW
D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

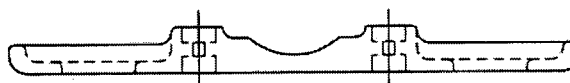
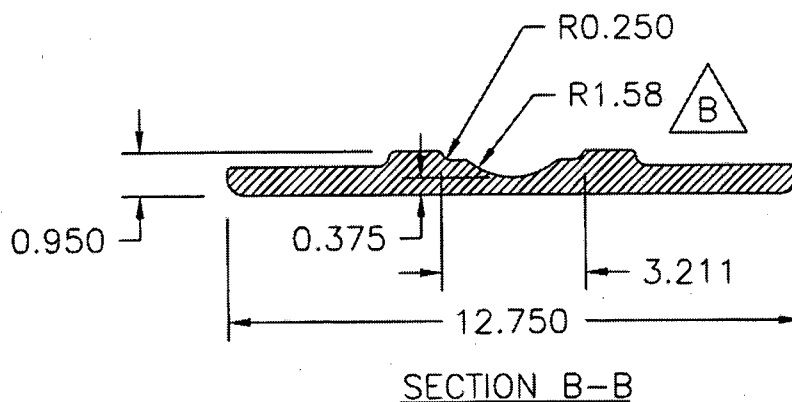
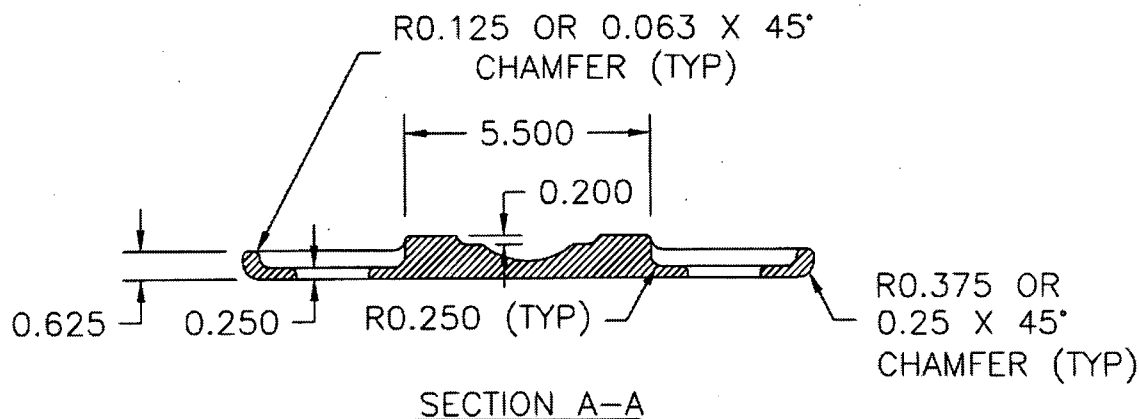
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 11734



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>ME</i>	APPROVED <i>KE</i>	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE



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